



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5499-2
Job Sheet 188276



Part No: D5499-2

Job Qty: ~~6~~ pcs

12 pcs. 6 pcs

Part Name: Aft Bracket Mount



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/7/19

Job Tracking No:

Due Date: 1/11/19

April 17

Created By: Marie Lajeunesse

Type: ~~SOLD~~

Description:

Note: D5499-2 REV.B IPP REV.A NEW ISSUE 18/04/27 JFS VERIFIED BY:DD IPP REV:B 18/08/03 AS PER DWG
REV.B JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	HAAS 5 Axis	6 pcs	1/11/19	1/11/19	0.50	4.50	HAAS - 5	m/ 19-05-08
120	QC 2	6 pcs	1/11/19	1/11/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	m/
							QC 2 - 14	
							QC 2 - 17	m/
							QC 2 - 19	
							QC 2 - 2	m/ 19-05-08
							QC 2 - 20	
							QC 2 - 22	m/
							QC 2 - 23	
							QC 2 - 25	m/
							QC 2 - 32	
							QC 2 - 33	m/
							QC 2 - 35	
							QC 2 - 38	m/
							QC 2 - 39	
							QC 2 - 4	m/
							QC 2 - 40	
							QC 2 - 44	m/
							QC 2 - 45	
							QC 2 - 48	m/
							QC 2 - 49	
							QC 2 - 50	m/
							QC 2 - 51	
							QC 2 - 52	m/
							QC 2 - 54	
							QC 2 - 56	m/
							QC 2 - 57	
							QC 2 - 62	m/
							QC 2 - 63	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
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www.dartaerospace.com

Container No: S179464



Part: D5499-2

Job No: 188276

Serial No/Batch: S179464

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/08/19

130 QC 8	6 pcs	1/11/19	0.00 0.00	QC 2 - 8	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20 QC 8 - 23	VH8 19/5/19
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	1/11/19	0.00 0.50	Handfinish - 1 - 1 - B4B	3EB19-05-09
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	6 pcs	1/11/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	

					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 38	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 6	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
180	Packaging 3-1 - Stock - B4B	6	1/11/19	0.00 0.00	Packaging 3 - 1 - B4B	
		pcs			Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	

DAS 30 2-89

MAY 0 2019

DAS 28 2-89

190 QC 21 - SA 6 1/11/19 0.00 0.00 QC 21 - SA - 21
 pcs QC 21 - SA - 70

DWG
21
9-89

MAY 09 2019

GA-760

Part Op 110 - (HAAS CNC vertical machine #5) 1-Machine per folio FC024. DWG REV: B FOLIO REV: A4 2-
 Descriptions: Deburr and break all sharp edges.
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - QC21- Final Inspection - Work Order Release)

MAT
used
4.918'

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B3.500X03.500	6061-T6 Bar 3.5" X 3.5" (Cut To 6 ft)	2.4420 ft (.407 ea)	110-HAAS 5 Axis	M1350 49

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-HAAS 5 Axis	M6061T6B3.500X03.500	2	12	0

SCRAP
3.25'

Part Specifications

Specifications could not be found.

Plex 1/22/19 3:30 PM Dart.Hadley.Shannon

478
 8.125'
 $12 \times 8.125 = 97.50$
~~12 x 8.125~~



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D5499-2

Job Sheet 188276



Part No: D5499-2

Job Qty: 1 ea

Part Name: Aft Bracket Mount



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/7/19

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

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REV.B JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/11/19	0.00	0.00	Start Up Machining-2		
110	CNC Vertical Machining	1 pcs		1/11/19	0.50	0.75	HAAS 5 Axis		
120	QC	1 pcs		1/11/19	0.00	0.00	QC2 Machining-2		
130	QC	1 pcs		1/11/19	0.00	0.00	QC8 Machining-2		
140	HandFinish	1 pcs		1/11/19	0.00	0.08	HandFinish1		
150	QC	1 pcs		1/11/19	0.00	0.00	QC7-5		
180	Packaging	1 pcs		1/11/19	0.00	0.00	Packaging3-2		
190	QC21-SA	1 Ea		1/11/19	0.00	0.00	QC21		

Part Op 90 - Cut Blank to 4.875"

Descriptions: 110 - 1-Machine per folio FC024. DWG REV: _____ FOLIO REV: _____ 2- Deburr and break all sharp edges.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B3.500X03.500	6061-T6 Bar 3.5" X 3.5" (Cut To 6 ft)	.4070 ft (.407 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B3.500X03.500	0	12	0

Part Specifications

Specifications could not be found.

Plex 1/7/19 10:46 AM Dart.lajeunesse.marie

H5

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	188276
Description: AFT BRACKET MOUNT		Part Number:	15499-2
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.69	± 0.030	.690	—		Vern M/LD	
.33	± 0.030	.330	—		"	
R.13	± 0.030	R.125	—		R-6	
R.13	± 0.030	R.125	—		"	
R.25	± 0.030	R.250	—		"	
2.65	± 0.030	2.653	—		Vern M/LD	
.623	± 0.010	.617	—		"	
.13 X 45°	$\pm 0.030 \times \pm 1/2^\circ$	.126 X 45°	—		"	
Ø.191	$\pm .0015$	Ø.191	—		"	
R.13	± 0.030	R.125	—		R-6	
.80	± 0.030	.799	—		Vern M/LD	
.760	± 0.005	.763	—		"	
2.49	± 0.030	2.490	—		"	
1.92	± 0.030	1.915	—		"	
.40	± 0.030	.401	—		"	
R.17	± 0.030	R.170	—		"	
Ø 1.245	$\pm .0010$	1.236	—		"	
1.50	± 0.030	1.497	—		"	
1.337	± 0.005	1.339	—		"	
3.506	± 0.005	3.504	—		"	
.229	± 0.010	.229	—		"	
.80	± 0.030	.800	—		"	
.343	$\pm .005$	.344	—		"	
2.09	± 0.030	2.090	—		"	
Ø.191	$\pm .0015$	Ø.191	—		"	
1.250	$\pm .0010$	1.2525	—		"	
Ø.257	$\pm .0010$	Ø.260	—		"	
.800	± 0.030	.805	—		"	
4.66	± 0.030	4.655	—		"	

Measured by: <i>any</i>	Checked by: <i>HT</i>	QC Inspector:
Date: 19/05/07	Date: 19/5/89	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	